

Split

Work Order ID 84369-1

\*84369\*

Page 1

Item ID: D4062-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Upper Tank Support

Start Date: 10/05/2012 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 24/05/2012 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/10

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4062

C

100

0.00

\*100\*

Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT BLANK AS PER FILE D4062-1 BLANK

4

0

Jm

12-6-6

UHMW 1" Blk

102

QC2- Inspect parts off machine FAI/FAIB

0.00

\*102\*

QC

Memo

0.00

Quality Control

12-6-7

3

4

105

0.00

\*105\*

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

MILL AS PER DWG AND FOLIO FA949

DWG REV: 2

FOLIO REV: 1/1

12-6-7

3

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Work Order ID 84369

May-10-12 2:34:59 PM

**\*84369\***

Page 2

Item ID: D4062-1

Accept

**\*N9000040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Upper Tank Support

Start Date: 10/05/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 24/05/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

106

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*106\***

QC

Memo

0.00

Quality Control

24 12-C-7

34 2

130

QC8- Inspect parts - second check

0.00

**\*130\***

QC

Memo

0.00

Quality Control

BA 12/06/07

3 4

140

Identify as per dwg & Stock Location

0.00

**\*140\***

Packaging

Memo

0.00

Packaging

WA  
PAT

(3)

12/6/84

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Work Order ID 84369

May-10-12 2:34:59 PM

**\*84369\***

Page 3

Item ID: D4062-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Upper Tank Support

Start Date: 10/05/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 24/05/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC21- Final Inspection - Work Order Release

0.00


**\*150\***

QC

Memo

0.00

Quality Control

12/6/11 

MF  
12-06-08



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

May-10-12 2:35:02 PM

Page 1

Work Order ID: 84369

\*84369\*

Parent Item: D4062-1

\*D4062-1\*

Parent Item Name: Upper Tank Support

Start Date: 10/05/2012

Required Date: 24/05/2012

Start Qty: 4.00

Required Qty: 4.00

## Comments:

IPP REV:A NEW ISSUE 10-06-22 JLM VERIFIED BY:DD  
 REV:B AS PER REV B 11-11-23 JLM VERIFIED BY:DD  
 AS PER REV C 12-03-08 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MUHMWB10

Purchased

No

sf

53.2100

14.4

\*MUHMWB10\*

\*\*

UHMW 1" Black

B12-6-5

## Location

## Loc Qty

## Loc Code

MAT018

30.1

120972

3

121346

27.1

MAT019

1.5

118814

1.5

ST052

21.60999474

121277

12.8

121278

8.80999474

121954

121954

JM  
12-6-6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

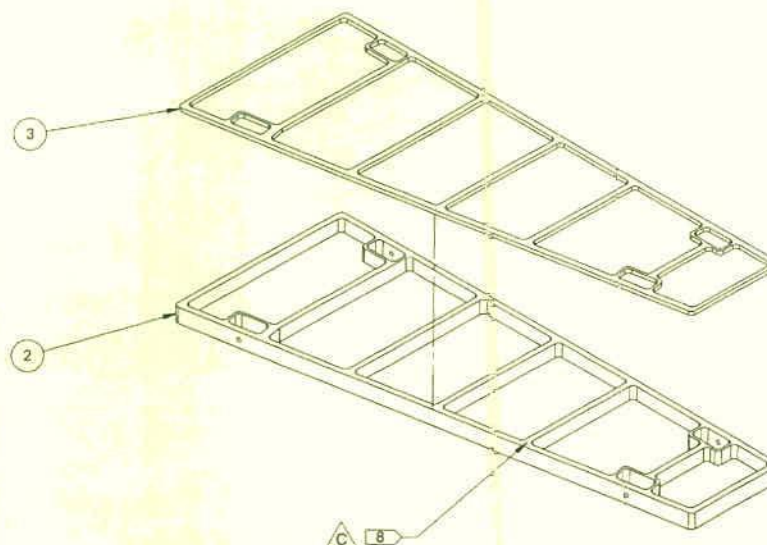
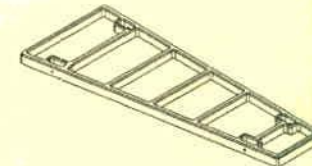
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4062-041	TANK SUPPORT ASSEMBLY
2	1	D4062-1	LOWER TANK SUPPORT
3	1	D4062-3	UPPER TANK SUPPORT



# **D4062-041 TANK SUPPORT ASSEMBLY**

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.91 lbs
- 8) BOND ITEMS 2 & 3 TOGETHER USING PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 84368 MLJ  
12/05/10

2012-03-02

C	REMOVE HARDWARE TO ATTACH ITEMS 2 & 3. REMOVE C/BORE	DC	11.12.14
B	MODIFIED DIMS & DESIGN OF -1, ADDED -3/-041	DC	11.09.29
A	NEW ISSUE	HS	10.07.26
REV	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO. <b>D4062</b>	REV. C
MFG. APPR.		SHEET 1 OF 3	
APPROVED		TITLE	SCALE
DE APPR.		<b>TANK SUPPORT</b>	NTS
DATE	<b>11.12.14</b>	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

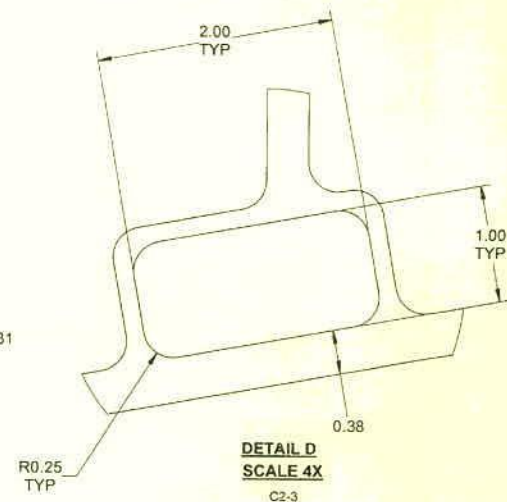
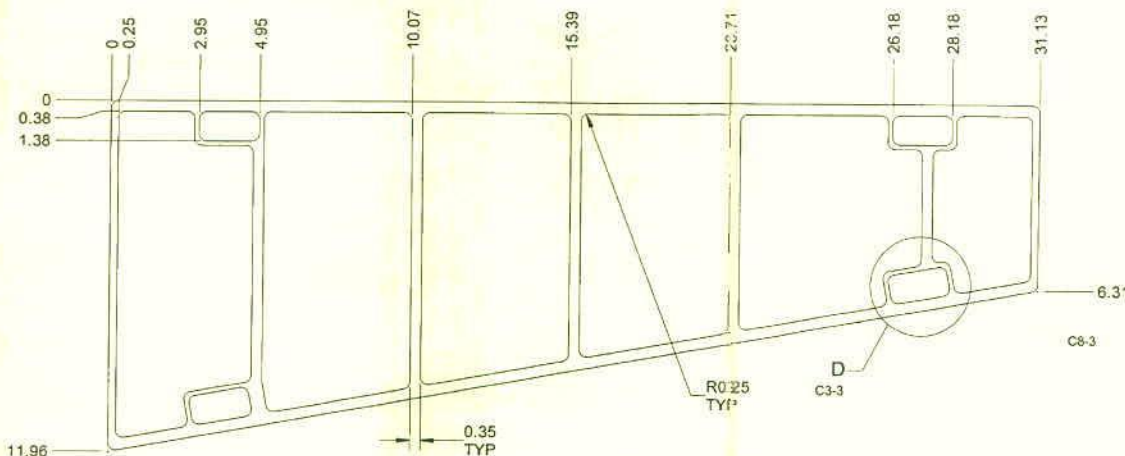
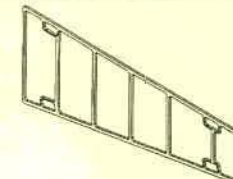
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



84369



**D4062-3 UPPER TANK SUPPORT**

**NOTES:**

- 1) MATERIAL: BLACK UHMW TIVAR 1000 VIRGIN MATERIAL SHEET, 0.25 THICK  
REF DART SPEC MUHMWB025
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.37 lbs
- 8) CUT PER D4062-3.DXF

RELEASED  
2012-03-02  
NN

DESIGN	JE	<b>DART AEROSPACE LTD</b> HAWKESSBURY, ONTARIO, CANADA	
DRAWN	JE		
CHECKED	JE	DRAWING NO.	REV. C
MFG. APPR.	JE	D4062	SHEET 3 OF 3
APPROVED	JE	TITLE	SCALE
DE APPR.	JE	TANK SUPPORT	NTS
DATE	11.12.14	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 84369
<b>Description:</b> Lower TANK support		<b>Part Number:</b> D4662-1
<b>Inspection Dwg:</b>	<b>Rev:</b>	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.50	+/- .030					Transfer drill in G.A
3.94	+/- .030					
23.36	+/- .030					
.257	+ .006 - .001					
1.00 ref	+/- .030	1.006	/			
.13	+/- .030	.135	/			
.38	+/- .030	.375	/			
.38	+/- .030	.374	/			
3.07	+/- .030	3.07	/			
26.30	+/- .030	26.30	/			
.50	+/- .030					Transfer drill in G.A
4.02	+/- .030					
23.85	+/- .030					
2.00	+/- .030	1.998	/			
.38	+/- .030	.360	/			
1.00	+/- .030	1.002	/			
.35	+/- .030	.355	/			

Measured by: RC  
Date: 12-6-7

Audited by: B.A  
Date: 12/06/07

Preliminary Approval: \_\_\_\_\_  
Date: \_\_\_\_\_

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

26